

## ABSTRACT

Novel elements are provided to erect a female blanking die for a die cutting machine for die cutting and/or blanking a carton blank, as well as for erecting a combination male blanking die/female blanking die. The novel elements include the following specifically-described elements: jogger members; auxiliary adjustable support members; grid orientation cylinders; grid support brackets; template corner locking clamps; centre line orientation cylinders; centre line clamps; and rail connecting elements. The novel rail connecting elements serve to erect a rectangular framework for the universal press frame of the female blanking die wherein the front and the rear rails are disposed at a higher level than the side rails. Novel embodiments of jogger members are provided which are selectively-disposed along the internal perimeter of the rectangular framework for erecting the female blanking die, each such novel jogger member having a particularly-recited structure. Novel centre line orientation clamps and centre line orientation cylinders are provided, in combination with a template, to place the template accurately within the rectangular framework. Novel grid support brackets are provided in the rectangular framework, and grid orientation cylinders are provided on the template for holding a grid which comprises a plurality of intersecting rails, the pattern of the intersecting rails having a predefined shape of the abutting portions of blanked cartons. The grid is adapted to be disposed within slots atop the grid support brackets and in the grid support cylinder. Novel auxiliary adjustable support members may also selectively-disposed along the internal perimeter of the rectangular framework for erecting the female blanking die. Novel legs support the rails constituting a universal press frame for erecting the female blanking die, the legs being later removed to provide the female blanking die.